Work Order ID 47936

Friday, June 26, 2009 8:59:56 AM

Item ID: D350-591-121
Revision ID: E
Item Name: Heli,Access-Step, LH

Accept

Setup Start
Stop

Start Date: 7/15/2009 **Start Qty:** 4.00
Required Date: 8/3/2009 **Req'd Qty:** 4.00
Reference:

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D2351	Rev E

100 — 0.00

DC — DOCUMENT CONTROL

Document Control

Memo 09/06/24 — 0.00

Photocopy bluefile and type labels as per PPP D350-591-121CHG004

S 08/07/01

110 — 0.00

Large Fab — Large Fab

Large Fab

Memo — 0.00

1-Cut D2244-116 extrusion to 55.32" long as per Dwg D2351 using cutting table setup DT8185-G□2-Drill extrusion per Dwg D2351 using Jig DT8230 for rivets.
□B38023 x4) -
3-Deburr
B38023 x4

SAD 09-06-30

120 — 0.00

CNC Bend 1 — BENDING MACHINE - SKIDTUBES

CNC Delta 100 Bender

Memo — 0.00

Bend per Dwg D2351 using Bend Program ~~D23561dD~~ FT011

Use Bend Prog D2351-041
09/07/06

9-7-8

(Pb)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-591-121 PAR #: N/A Fault Category: Large Fab NCR: (Yes) No DQA: Date: 09.07.22

Resolution: Scrap Disposition: Scrap QA: N/C Closed: Date: 05.08.14

NCR: 47936		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B: Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
9/7/06	120	Qty (4) Step (ALL) one over Bent. - two have cracks at the last Rivet hole.	RDS/CM2	Scrap and Destroy Qty x4 steps	9-7-06	07/07/08	RDS/CM2	07/07/06
				Replace Qty 4 B38023				
		- two have the last Rivet hole egged shaped R4 Bend was started @	RDS/CM2		SAD 09-07-07	07/07/08	RDS/CM2	07/07/06
		wrong location 18¾-7/9" ⇒ wrong Bend Program on w/o	RDS/CM2				RDS/CM2	07/07/06

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 47936

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Start Date: 7/15/2009 **Start Qty:** 4.00
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Run **Start**
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
140		0.00							
Large Fab	Large Fab								
Large Fab	Memo	0.00							
	1-Bevel Fwd and Aft end for welding□2-Weld Aft End Bracket per QSI 004 & Dwg D2351 using Welding Jig DT8033□ A/RAluminum Rod 110922□3- Do not Grind Flush								
150	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									

=> 8 08/07/08 (4)

09.07.09

09/07/09 (4)

Work Order ID 47936

Friday, June 26, 2009 8:59:56 AM

Item ID: D350-591-121
Revision ID: E
Item Name: Heli-Access-Step, LH

Accept

Setup **Start**
Stop

Start Date: 7/15/2009 **Start Qty:** 4.00
Required Date: 8/3/2009 **Req'd Qty:** 4.00
Reference:

Cust Item ID:
Customer:

Run **Start**
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00	27 Sep 2009		(XC)				
170 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 **Memo**	0.00 0.00	BK 09-07-13			(4)			
180 QC Quality Control	QC3- Inspect Part Finish **Memo**	0.00 0.00	N 09-07-13		(XC)				

Work Order ID 47936

Friday, June 26, 2009 8:59:56 AM

Item ID: D350-591-121
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Item Name: Heli-Access-Step, LH

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Setup Start
Stop

Start Date: 7/15/2009 **Start Qty:** 4.00
Required Date: 8/3/2009 **Req'd Qty:** 4.00
Reference:

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 Large Fab Large Fab	Large Fab **Memo** 1-Rivet Leg Assembly as per Dwg D2351	0.00 0.00				4 09-07-14			
200 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00				4 08/07/14	0		
210 Large Fab Large Fab	Large Fab **Memo** 1-Weld Fwd End Plate per QSI 004 & Dwg D2351 ☐ A/RAluminum Rod M110130 ☐2-Grind end cap flush per dwg D2351	0.00 0.00				4 09-07-14			

Work Order ID 47936

Friday, June 26, 2009 8:59:56 AM

Item ID: D350-591-121
Revision ID: E
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Accept

Setup **Start**
Stop

Start Date: 7/15/2009 **Start Qty:** 4.00
Required Date: 8/3/2009 **Req'd Qty:** 4.00
Reference:

Cust Item ID:
Customer:

Run **Start**
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds	0.00	DD 09.07.15		(4)				
	Memo	0.00							
230 QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00	=> S 09/07/15		(X4)				
	Memo	0.00							
240 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1	0.00	UMO 09/07/15		(X4)				
	Memo	0.00							

Work Order ID 47936

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Setup Start
Stop

Start Date: 7/15/2009 **Start Qty:** 4.00
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Reference:

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
	Pressure wash MD 09/07/15 (x4)								
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 1:50pm OVEN TEMPERATURE: 2:20pm FINISH TIME: 320°F M112148 09-07-15 (x4) JH								
260	~~Pressure Wash per QSI005 4.3~~	0.00							
	Wing Walk MD 09/07/15					MD 09/07/15 (x4)			
HandFinish	Memo	0.00							
Hand Finishing	BATCH: M111013								
270	QC3- Inspect Part Finish	0.00							
	BL 09-07-16 (A).								
QC	Memo	0.00							
Quality Control									

Work Order ID 47936

Friday, June 26, 2009 8:59:56 AM

Item ID: D350-591-121
Revision ID: E
Item Name: Heli-Access-Step, LH

Accept

Setup Start
Stop

Start Date: 7/15/2009 **Start Qty:** 4.00
Required Date: 8/3/2009 **Req'd Qty:** 4.00
Reference:

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	Pick Kit	0.00				9/7/17		(4)	SP
Packaging	Memo	0.00							
Packaging									
290	QC4- 100% Inspect kits for completeness	0.00				(44)			
QC	Memo	0.00							
Quality Control									
300	Packaging	0.00				9/7/20		(40)	SP
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-591-121 ☐Location: 8G ☐PPP Rev: E								

=> Sorlabl

Work Order ID 47936

Friday, June 26, 2009 8:59:56 AM

Item ID: D350-591-121
Revision ID: E
Item Name: Heli-Access-Step, LH

Accept

Setup Start
Stop

Start Date: 7/15/2009 **Start Qty:** 4.00
Required Date: 8/3/2009 **Req'd Qty:** 4.00
Reference:

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
310	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	**Memo**	0.00							

09/07/22

MF 09·07·22

Picklist Print

Friday, June 26, 2009 8:59:55 AM

Work Order ID: 47936

Parent Item: D350-591-121RevE

Parent Item Name: Heli-Access-Step, LH

Comments:

Start Date: 7/15/2009 **Required Date:** 8/3/2009

Start Qty: 4.00 **Required Qty:** 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L4 x3 Nut		Purchased	No		290	~~110~~	Each	0.0000	12.0000	3x	M110501	SP
D2244-116RevD1 Step Extrusion		Manufactured	No		110	~~140~~	Each	0.0000	4 ~~2~~.0000		B38023 → SAO 09-0630	
D2582RevB Step Leg Assembly		Manufactured	No			190	Each	0.0000	9 ~~4~~.0000		~~B38023~~ 47644	
D2850-1RevA End Bracket		Manufactured	No		140	~~190~~	Each	0.0000	4.0000		B26919 3 B31408=1	
MS20600-AD4W3 Cherry Rivets		Purchased	No		190	210	Each	0.0000	64.0000		M106375	
AN3-37A x2 Bolt		Purchased	No			290	Each	0.0000	8.0000	2	M105425	SP
AN4-13A x3 Bolt		Purchased	No			290	Each	0.0000	12.0000	3	M111925	SP
AN960JD10 x4 Washer		Purchased	No			290	Each	0.0000	16.0000	4	M111668	SP
AN960JD416 x6 Washer		Purchased	No			290	Each	0.0000	24.0000	6	M111279	SP

4E 9/7/14

Picklist Print

Friday, June 26, 2009 8:59:55 AM

Work Order ID: 47936

Parent Item: D350-591-121RevE

Parent Item Name: Heli-Access-Step, LH

Comments:

Start Date: 7/15/2009 **Required Date:** 8/3/2009

Start Qty: 4.00 **Required Qty:** 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2230-1RevF Lug		Manufactured	No			290	Each	0.0000	4.0000	48299		SO
D2230-3RevF Lug		Manufactured	No			290	Each	0.0000	4.0000	47965		SO
D2673-34RevB End Plate		Manufactured	No		210	~~290~~	Each	0.0000	4.0000	336406		
D2856-400RevA Abraison Strip		Manufactured	No			290	f	0.0000	2.4000	46543		
MS21042L3 Nut		Purchased	No			290	Each	0.0000	8.0000	M111274	9/7/17	

Date: Wednesday, 13/05/2009 11:29:15 AM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 47936
Estimate Number : 11672
P.O. Number :
This Issue : 13/05/2009 **S.O. No.** :
Prsht Rev. : NC
First Issue : / / **Type** : LARGE FAB ASSY
Previous Run : 47623
Written By :
Checked & Approved By : JLD 09.05.13
Comment : Est Rev:E 02.10.21 Re-format; Incorporated D2351-041 IPP K J/RF
est rev. F 06.02.23 added grinding EC
Est Rev: G 09.05.06 Update comment on step 4 KJ Verified by:

Drawing Name : SHORT STEP ASSEMBLY
Part Number : D350591121
Drawing Number : D2351 ~~UNDER REVIEW~~ E 09.05.13
Project Number : N/A
Drawing Revision : E
Material :
Due Date : 29/05/2009 **Qty:** 4 **Um:** Each

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Photocopy bluefile and type labels as per PPP D350-591-121CHG004

Seq. #:	Machine Or Operation:	Description :
2.0	D2244116	Step Extrusion

Comment: Qty.: 0.5000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
0.5	D2244-116	Extrusion	B38023

SAD 09-06-30 (4)

Seq. #:	Machine Or Operation:	Description :
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244-116 extrusion to 55.32" long as per Dwg D2351 using cutting table setup DT8185-G

2-Drill extrusion per Dwg D2351 using Jig DT8230 for rivets.

3-Deburr SAD 09-06-30 (4)

Seq. #:	Machine Or Operation:	Description :
4.0	BENDING	BENDING MACHINE - SKIDTUBES

Comment: BENDING MACHINE
Bend as per Dwg D2351-041 using CNC Bender 1 and Folio FT011. Use Bend Program D2351-041. 9-7-8

Date: Wednesday, 13/05/2009 11:29:15 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SHORT STEP ASSEMBLY

Job Number: 47936 **Part Number:** D350591121

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	07/07/09
6.0	D28501	End Bracket
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2850-1 End Bracket B26919	09.07.09 4
7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
	Comment: LARGE FABRICATION RESOURCE 1 1-Bevel Fwd and Aft end for welding	09.07.09 4
	2-Weld Aft End Bracket per QSI 004 & Dwg D2351 using Welding Jig DT8033 A/R Aluminum Rod M110130 M110972	09.07.10 4
	3-Do not Grind Flush	09.07.10 4
8.0	QC9	VISUAL WELDING INSPECTION
	Comment: VISUAL WELDING INSPECTION	BE 09-07-10 4
9.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	07/07/09
10.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	09-07-10
11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	09.07.14 4

Form: rprocess

Date: Wednesday, 13/05/2009 11:29:15 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SHORT STEP ASSEMBLY

Job Number: 47936 **Part Number:** D350591121

Job Number:

Seq. #:	Machine Or Operation:	Description :
12.0	D2582	Step Leg Assembly

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2582	Step Leg Assy	B47644

09.07.14 4

13.0	MS20600AD4W3	Cherry Rivets

Comment: Qty.: 16.0000 Each(s)/Unit Total : 64.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
16	MS20600AD4W3	Rivet	M106375

09.07.14 4

14.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Rivet Leg Assembly as per Dwg D2351 09-07.14 4

15.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP 07/07/14

16.0	D267334	End Plate

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2673-34	End Plate	B36406

09.07.14 4

17.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Weld Fwd End Plate per QSI 004 & Dwg D2351
A/R Aluminum Rod M110130 09.07.14 4

2-Grind end cap flush per dwg D2351 09.07.14 4

Form: rprocess

Date: Wednesday, 13/05/2009 11:29:15 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SHORT STEP ASSEMBLY

Job Number: 47936 **Part Number:** D350591121

Job Number:

Seq. #:	Machine Or Operation:	Description :
18.0	QC9	VISUAL WELDING INSPECTION
	Comment: VISUAL WELDING INSPECTION	A 09-07-15
19.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	S 02/07/15 (x4)
20.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Touch up Alodine	UMD 09/07/15 (x4)
21.0	POWDER COATING	POWDER COATING
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 START TIME: 1:50pm OVEN TEMPERATURE: 320°F FINISH TIME: 2:20pm	M112148 Pressure wash UMD 09/07/15 (x4) 09-07-15 (x4)
22.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Wing Walk per Dwg D2351 and QSI 005 4.4 Batch: M111013	UMD 09/07/16 (x4)
23.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	09-07-16 (4)
24.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Pick Packing Kit	9/7/20 SO (4)
25.0 ✓	D22301	Lug
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Packing KitQty Part Number Description Batch	

Date: Wednesday, 13/05/2009 11:29:15 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SHORT STEP ASSEMBLY

Job Number: 47936 **Part Number:** D350591121

Job Number:

Seq. #:	Machine Or Operation:	Description :

1 D2230-1 Mounting Lug _____

26.0 D22303 Lug

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick:
Packing KitQty Part Number Description Batch
1 D2230-3 Mounting Lug _____

27.0 D2856400 Abraison Strip

Comment: Qty.: 0.6000 f(s)/Unit Total : 2.4000 f(s)
Pick:
Packing KitQty Part Number Description Batch
1 D2856-400 7.20" Abrasion Strip _____

28.0 AN337A Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
Pick:
Packing KitQty Part Number Description Batch
2 AN3-37A Bolt _____

29.0 AN413A Bolt

Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)
AN4-13A
Batch:_____

30.0 AN960JD10 Washer

Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)
Pick:
Packing KitQty Part Number Description Batch
4 AN960JD10 Washer _____

31.0 AN960JD416 Washer

Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)
Pick:
Packing KitQty Part Number Description Batch
6 AN960JD416 Washer_____

Form: rprocess

Date: Wednesday, 13/05/2009 11:29:15 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SHORT STEP ASSEMBLY

Job Number: 47936 **Part Number:** D350591121

Job Number:

Seq. #:	Machine Or Operation:	Description :
32.0	MS21042L3	Nut

Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
Pick:

Packing Kit	Qty	Part Number	Description	Batch
	2	MS21042L3	Nut (or -3)	_____

33.0	MS21042L4	Nut

Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)
Pick:

Packing Kit	Qty	Part Number	Description	Batch
	3	MS21042L4	Nut (or -4)	_____

34.0	QC4	INSPECT 100% KITS FOR COMPLETENESS

Comment: INSPECT 100% KITS FOR COMPLETENESS 04/07/21 (XX)

35.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D350-591-121
Location:_____
PPP Rev:_____

36.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

Form: rprocess

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
KE	PH	
CHECKED	APPROVED	DRAWING NO. REV. E
		D2351 SHEET 1 OF 2
DATE		TITLE SCALE
05.11.14		HIGH FLOAT STEP ASSEMBLY NTS

A	95.02.15	NEW ISSUE
B	97.05.22	END CAPS CHANGED
C	97.07.23	ADDED BUSHING AND FACING INFO
D	98.12.17	CHANGED TO BEND, D2850 REPLACES D2357 & D2358, INCORP. DEO 9084
E	05.11.14	UPDATE FINISHING NOTE

D2351 HIGH FLOAT STEP ASSEMBLY PARTS LIST

Part No.	Description	QTY -041	QTY -042
D2351-041	**High Float Step Assembly (LH)**	**X**	
D2351-042	**High Float Step Assembly (RH)**		**X**
D2244-55.4	STEP EXTRUSION*	1	1
D2582	STEP LEG ASSEMBLY	1	1
D2673-34	STEP END PLATE	1	1
D2850-1	END BRACKET	1	
D2850-2	END BRACKET		1
MS20600AD4W3	RIVETS	16	16

*cut per drawing

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 4193

RELEASED
05.11.28

UNDER REVIEW
ECN 1105
07.11.24
PER ECN# 263

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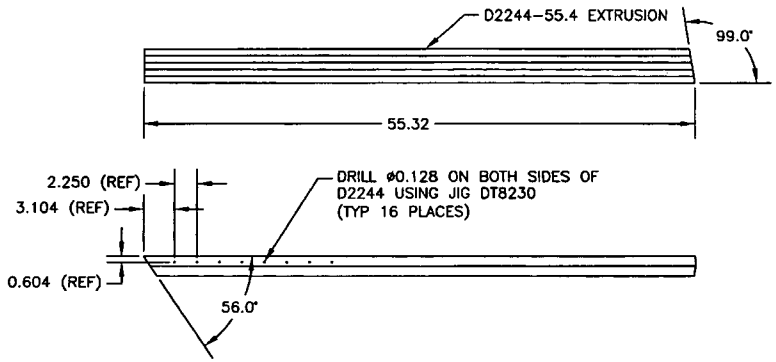
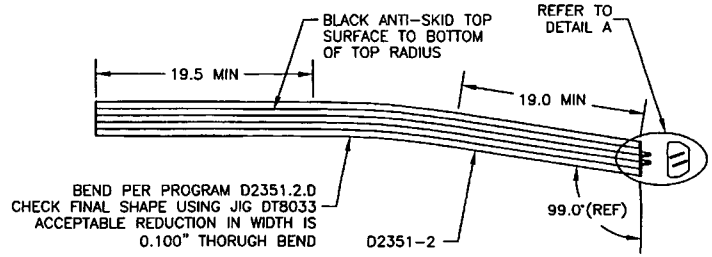
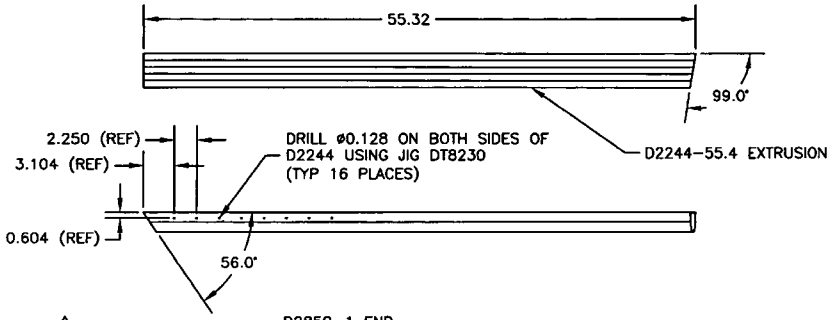
D2351-2 CUTTING/DRILLING DETAIL
RIGHT STEP



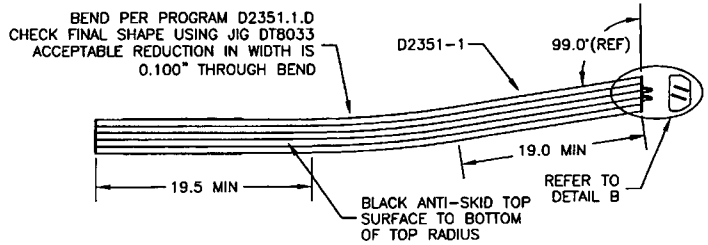
D2351-042 BENDING/ASSEMBLY DETAIL
RIGHT STEP

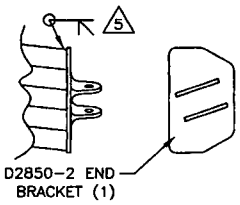


D2351-1 CUTTING/DRILLING DETAIL
LEFT STEP

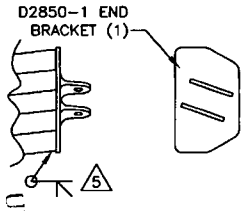


D2351-041 BENDING/ASSEMBLY DETAIL
LEFT STEP

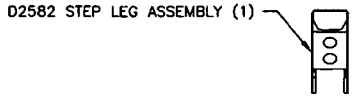


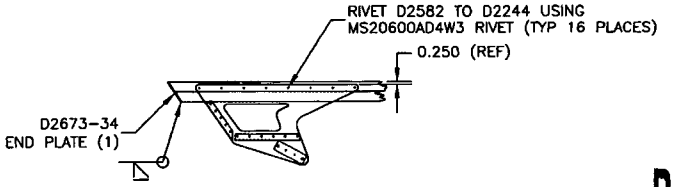


DETAIL A
SCALE: 1:4



DETAIL B
SCALE: 1:4





GENERAL NOTES
1) WELD PER DART QSI 004
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5 CHAMFER D2244 EXTRUSION 0.075"x45° BEFORE WELDING D2850-1 OR D2850-2 IN PLACE. DO NOT GRIND FLUSH.

RELEASED
05.11.28

UNDER REVIEW

ECN 1105

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DESIGN: KE	DRAWN BY: PH	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2351	REV. E SHEET 2 OF 2
DATE 05.11.14		TITLE HIGH FLOAT STEP ASSEMBLY	SCALE 1:12